

Work Order ID-77191

November-28-11 2:22:35 PM

77191

Page 1

Item ID: DSK078

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: D2893-1 TURNING DETAIL

Start Date: 28/11/2011 Start Qty: 10.00

10

Cust Item ID:

Required Date: 12/12/2011 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 11/11/28

Tooling: _____ Date: _____

QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

DSK078

Rev A

100

0.00

100

Doosan

Memo

0.00

Doosan Lathe

Turn blank as per Folio FA081
(4TH AXIS PLUG DT8492)

SL 11/12/12

10 0

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

SL 11/12/12

10 0

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

SL 11-12-16

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval ³ QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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77191

Page 2

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 28/11/2011 **Start Qty:** 10.00

10

Cust Item ID:

Required Date: 12/12/2011 **Req'd Qty:** 10.00

10

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

130

0.00

130

0.00

Packaging

Memo

Identify and Stock in Kanban Location: MAT 055

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

140

0.00


QC

Memo

Quality Control

SL 11-12-16

10

11/12/19 

R 11-12-19
(108)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 77191

77191

Parent Item: DSK078

DSK078

Parent Item Name: D2893-1 TURNING DETAIL

Start Date: 28/11/2011

Required Date: 12/12/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP rev A. 08.03.13 new issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6104-005		Manufactured	No				Each	6.0000		10			
D6104-005									**				
Round Billet, 17-4													

SA 11/12/12

Location	Loc Qty	Loc Code
MAT047	6	
70254	3	
71179	1	
76308	2	

76834

10

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	77191
Description: Turning Detail for D2893-1		Part Number:	DSK078
Inspection Dwg: DSK078	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.707	2.712		2.712	2.712	2.712	2.712	2.712
B	4.946	4.966		4.958	4.958	4.958	4.958	4.958
C	3.064	3.084		3.073	3.074	3.074	3.074	3.074
D	0.718	0.738		.726	.726	.726	.726	.726
E	0.090	0.110		.102	.102	.102	.102	.102
F	2.934	2.954		2.942	2.944	2.944	2.944	2.944
G	2.166	2.186		2.176	2.176	2.176	2.176	2.176
H	3.890	3.910		3.899	3.900	3.901	3.900	3.901
I	0.914	0.934		.925	.925	.925	.925	.925
J	0.022	0.042		.031	.031	.031	.031	.031
K	0.109	0.129		.115	.116	.116	.115	.115
L								
M								
N								
O								
P								

Measured by: SL Date: 11/12/12

Audited by: SL Date: 11-12-16

Prototype Approval: _____ Date: _____

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	<u>SL</u>

DART AEROSPACE LTD		Work Order:	77191
Description: Turning Detail for D2893-1		Part Number:	DSK078
Inspection Dwg: DSK078	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

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Lathe Section								
A	2.707	2.712		2.712	2.712	2.712	2.712	2.712
B	4.946	4.966		4.958	4.958	4.958	4.958	4.958
C	3.064	3.084		3.074	3.074	3.074	3.074	3.074
D	0.718	0.738		.726	.726	.726	.726	.726
E	0.090	0.110		.102	.102	.102	.102	.102
F	2.934	2.954		2.944	2.945	2.944	2.945	2.944
G	2.166	2.186		2.176	2.176	2.176	2.176	2.176
H	3.890	3.910		3.900	3.901	3.900	3.901	3.900
I	0.914	0.934		.926	.926	.926	.926	.926
J	0.022	0.042		-.031	-.031	-.031	-.031	-.031
K	0.109	0.129		.116	.116	.115	.115	.115
L								
M								
N								
O								
P								

Measured by: SA Date: 11/12/12

Audited by: SA Date: 11-12-16

Prototype Approval: _____ Date: _____

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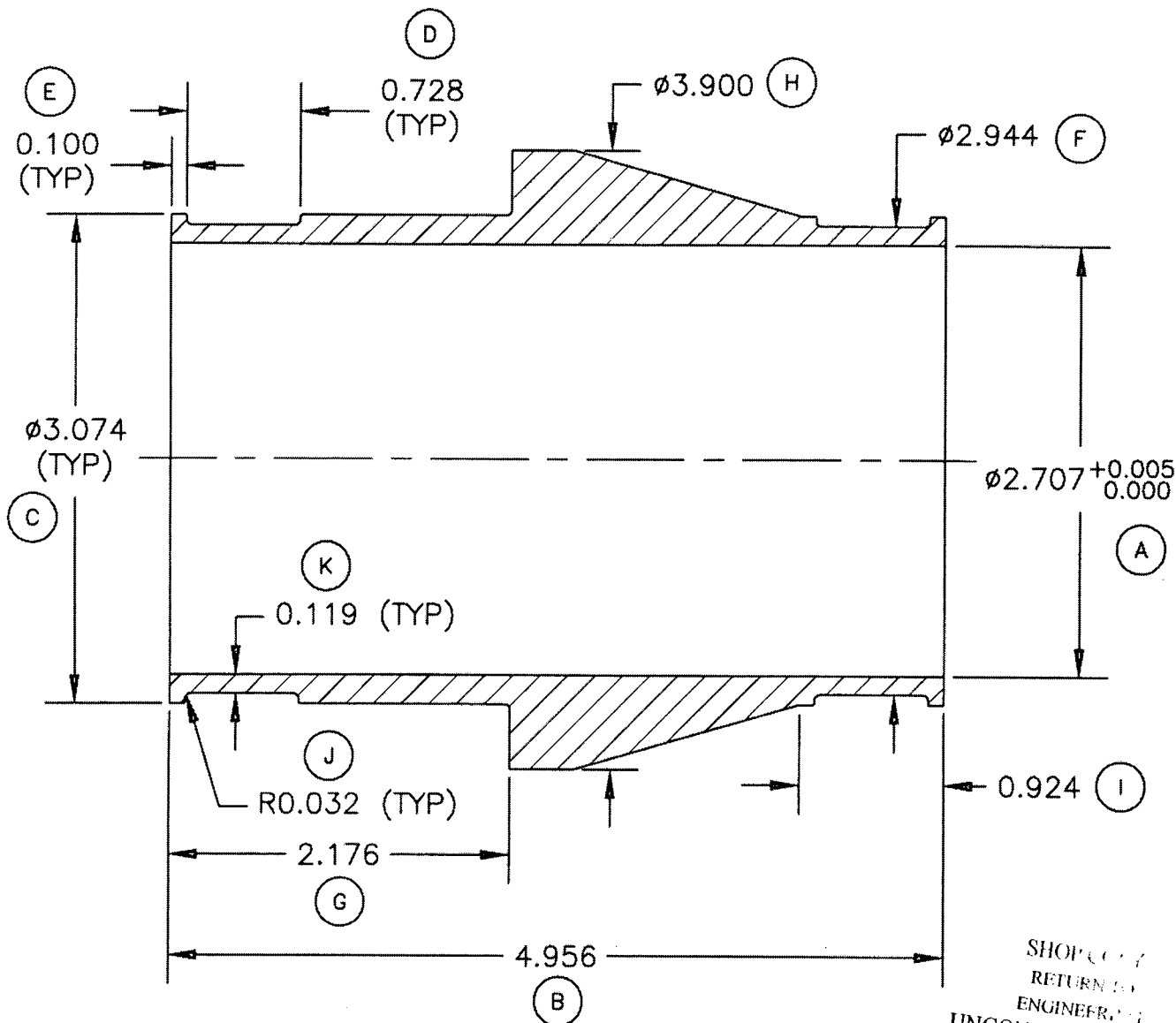
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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DESIGN KT	DRAWN BY KT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. DSK 078	REV. A SHEET 1 OF 1
DATE 03.05.20		TITLE TURNING DETAIL FOR D2893-1	SCALE 1:1
A	03.05.20	NEW ISSUE	

RELEASED
03.07.01



D2893-1 TURNING DETAIL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 77191-M.C.J
11/11/28

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